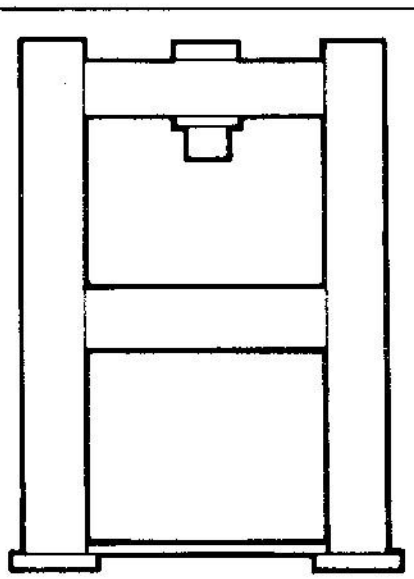
OPERATING INSTRUCTIONS

HYDRAULIC PRESSES 12-100 TONNES



ON RECEIVING YOUR PRESS

1. When unpacking the Press, check carefully and report any loss or damage to Carrier and Supplier **Immediately.**
2. Check over complete assembly and place Handle/Handles in position and tighten locking screw. Loosen Oil Filler Cap before use to expel air. Leave Oil Filler Cap Loose at all times. Cap should only be tight for TRANSPORTATION.
3. Secure to Floor.
4. The Press leaves the factory filled with the correct amount of oil. **Do Not** add Oil, unless Oil Loss has occured during Transport. Refer to Maintenance Sheet.
5. The Oil should be changed in all units every 12 months. Refill with correct amount and **GRADE OF OIL.** Refer to Maintenance Sheet.
6. **Do Not Use BRAKE OR SHOCK ABSORBER FLUIDS** as these WILL HARM the Oil Seals in the Pump and Cylinder.

On receipt of your Press, ensure that the machine is standing on a level firm surface before use. This applies to all models AND SECURE TO FLOOR.

Bench Models should be Fixed Firmly to a suitable Bench/Support. Secure Bench/Support Firmly to Floor.

Fit pump handles, the short handle for Low Pressure, long handle for High Pressure. Tighten screw.

Low Pressure Pump Fitted Only on Presses of 25 Tonne Capacity and Above.

12 Tonne to 20 Tonne Models have Double Acting Pumps and are fitted with Only One Pump Handle.

When a winch for moving a table is fitted, reverse handle. This is done by removing Hex Nut from winch spindle, remove and reverse handle, replace Hex Nut and ensure it is TIGHT.

TO POSITION TABLE

This is accomplished on all models without winch by lifting table to the required height, place pins in required location holes in frame, making sure that both pins are in line, lower table on to pins.

On models where a winch is fitted use the winch to lift and lower table to the required height. Replace pins AT EACH STAGE making sure that pins are in line, holding the pressure of the table on winch handle, remove winch locking lever —turn handle to allow table to settle on pins and replace winch locking lever to prevent cable from unspooling from winch.

Winch Ratchet Operates on Lifting Side Only.

NEVER SUPPORT table or load on WINCH CABLES. NEVER OPERATE PRESS with load supported on winch cables.

ALWAYS replace table support pins and allow table to be supported by pins at all times.

Winch ratchet operates only when lifting table. Make sure winch ratchet is always engaged for this purpose.

When lowering table disengage ratchet lever MAKING SURE THE WEIGHT OF THE TABLE IS HELD ON RATCHET HANDLE move table down one set of holes at time.

REPLACE PINS AT EACH STAGE.

NEVER ALLOW winch to freewheel, always hold table on winch handle.

TO USE PRESS

Close release valve situated in the centre of oil tank on models C12 to C30 DO NOT USE EXCESS PRESSURE.

On All other Models Release Valve is situated on Top Left Hand Side of Pump Tank.

Position work piece on table, use fast approach low pressure pump to engage press ram with work piece.

Low pressure pump handle is situated furthest away from the centre of press, use low pressure pump only to **pinch work piece.**

NEVER

Use a low pressure pump for pressure work, only for pinching work piece.

Apply pressure with High Pressure Pump until item being worked is free or until maximum working pressure is achieved. Release pressure release valve.

Use only Slow Smooth Action to Release Pressure.

Safety Features

1. Stroke Restricter Valve is fitted to all Press Cylinders. To Prevent Accidental Damage to Piston Rod Retaining Guide.
2. Plastic Bleed Tube On Cylinder.
   This allows any Oil that might gather on None Pressure side of Cylinder to be Returned to Oil Reservoir. **This function will only operate if the Oil Filler Cap is Loose.**
   It is a natural function for Oil to be seen moving along this Clear Plastic Tube.
3. Pressure overload valves are fitted to all Low Pressure and High Pressure Pumps.

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1. The Vee Blocks supplied with all Workshop Presses, can be used when positioned with Vee Slot reversed.
2. As Edge Parallel Blocks.
3. As a pressure plate for removing bearings from a shaft when the plates are positioned with the Vee in the centre forming a square.
4. With the two machined Vee's positioned on the outside edge the Vee Blocks can be used as a solid pressure plate.

THE FUNCTION OF THE STROKE RESTRICTOR VALVE FITTED TO ALL WORKSHOP PRESS HYDRAULIC CYCLINDERS

When the full working length of the Hydraulic Cyclinder Piston Rod has been reached. The Hydraulic Oil will pass from the Pressure Side of the Hydraulic Cylinder to the None Pressure Side of the Hydraulic Cylinder and pass through the clear plastic Bleed Tube to return to the Hydraulic Pump Oil Reservoir, at this stage the Pressure gauge will fluctuate indicating that hydraulic pressure is being lost. **DO NOT** continue to pump once the Full Piston Rod Length has been reached. At this stage Hydraulic Oil is being transferred from the Hydraulic Cylinder Top pass the Piston Seal into the bottom (none pressure side) of the Hydraulic Cylinder. If pumping is continued at this stage the oil in the Hydraulic Pump Reservoir will transfer to the None Pressure Side of the Hydraulic Cylinder.

SYMPTOMS

IF THIS CONDITION OCCURS THE PUMP WILL NOT REACH PRESSURE. DO NOT ADD HYDRAULIC OIL. BLEED THE SYSTEM.

1. Open the Hydraulic Pump Release Valve and allow the Hydraulic Cylinder Piston Rod to return to the FULLY CLOSED POSITION.
2. Close Hydraulic Pump Release Valve.
3. Pump until a MAXIMUM OF 60mm. of the Hydraulic Cylinder Piston Road has been extended from the Hydraulic Cylinder. At this stage **DO NOT EXCEED 60mm.** of Stroke. When pumping observe the Clear Plastic By Pass Tube, oil will pass through the Clear Plastic By Pass Tube and return to the Hydraulic Pump Reservoir. If Hydraulic Oil is still passing through the clear plastic By Pass Tube when 60mm. of stroke has been reached, Open the Hydraulic Pump Release Valve and return the Hydraulic Cylinder Piston Road to the Fully Closed Position, Close the Hydraulic Pump Release Valve and repeat the above operation until air bubles appear in the Clear Plastic By Pass Tube, it may be necessary to repeat this operation several times before air bubbles appear in the Clear Plastic Tube.
4. Open Hydraulic Pump Release Valve and return Hydraulic Cylinder Piston Road to the Fully Closed Position. The Hydraulic System has now been bled and the Press is ready for use. The Full Hydraulic Cylinder Stroke can now be used.

THE HYDRAULIC PUMP OIL FILLER CAP MUST REMAIN LOOSE AT ALL TIMES WHEN THE PRESS IS BEING USED OR THE SYSTEM IS BEING BLED.

TO BLEED SYSTEM

1. Loosen Oil Filler Cap situated at the Top of the Oil Reservoir. Do Not Add Oil Unit is Pre-Filled on Despatch from the Factory.
2. Fully Open Release Valve and Pump 11-12 Times with a Steady Pumping Action. (When a Low Pressure and High Pressure Pump is fitted carry out this operation on Both Pumps.)
3. Close the Release Valve DO NOT OVERTIGHTEN AS THIS COULD DAMAGE VALVE SEAT.
4. When Low and High Pressure Pump is fitted, Pump Low Pressure Pump until Ram Has Extended 60mm.
5. Stop Pumping and Open Release Valve, Wait until Ram has fully returned to close Position. Press is Now Ready for use.

   Do Not Pump Ram **Before Releasing Oil Filler Cap or Opening Release Valve.**

   Filler Cap Must Remain Loose at all times whilst Press is being Used.

   It is sometimes necessary to carry out the above operation several times to remove all the air from the system.

NEVER
Allow pressure gauge needle to enter the Red Danger Section marked on pressure gauge.

NEVER
Allow Ram to reach full stroke, this could damage seal or ram housing. Ram has spring assisted return.

NEVER
Use rods, tubes or any other means to extend the pump handles, if excessive power is employed accidents may occur.

MAINTENANCE
Although the Hydraulic Press is a simple machine, DO NOT NEGLECT IT. This could be expensive.

WEEKLY — Be sure the Press has sufficient oil. If the Press needs to be topped up Azolla ZS 32 OIL is recommended.

MONTHLY — Lubricate the moving parts of the Press structure.

YEARLY — Give the Press a general overhaul, ensure that all parts are free from defects, have them exchanged if necessary.

MAINTENANCE AND SERVICE SHEET (The correct amount of Oil)

Models 12 tonne to 20 tonne capacity 3 LT. 5 IMP. Pt.

Models 25 tonne to 60 tonne capacity 5 LT. 8 IMP. PT.

Model 100 tonne capacity 7 LT. 10 IMP. PT.

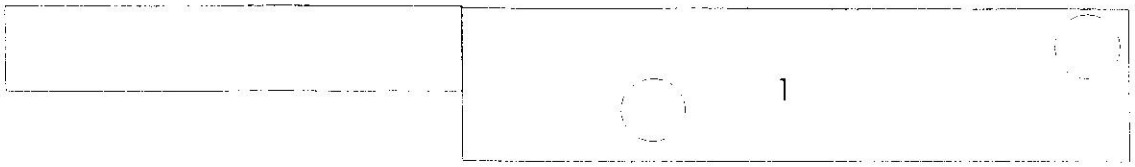
USE ONLY TOTAL AZOLA ZS32 HYDRAULIC OIL

Will Not Hold Pressure	Pump Fills Sponge Under Load	Oil Leaking From Ram	Fault Finding
X	X	X	Oil Filler Cap Not Loose
	X		The Hydraulic Pump-Ram could be Air Bound see Bleeding Instruction.
X	X		Release Valve Might Not Be Closed. Make sure Release Valve is Closed Correctly.
X	X		With Ram in the Fully Returned Position make sure Release Valve is closed correctly.
X	X		Low On Oil.

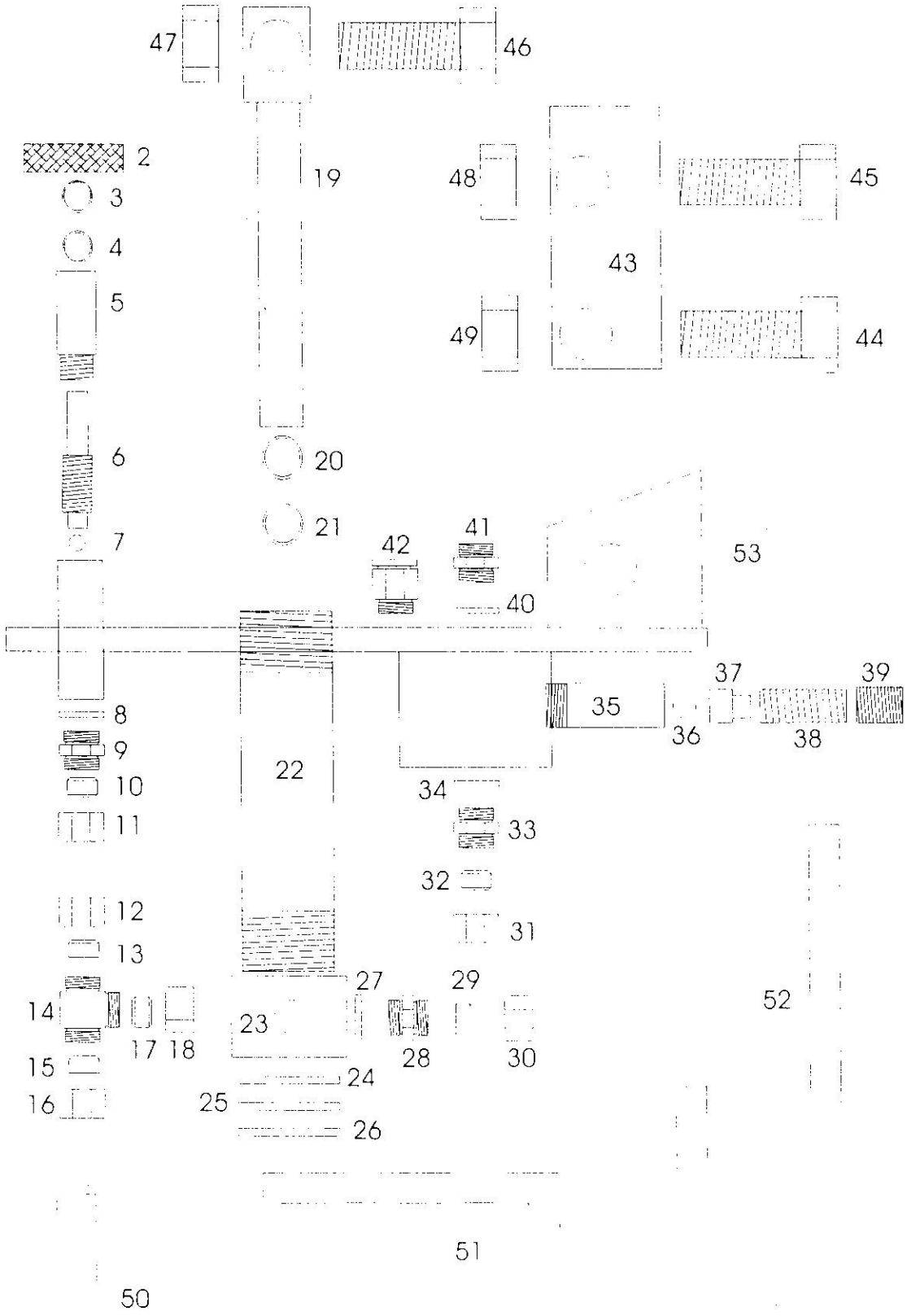
IMPORTANT THE CORRECT OIL FOR THIS UNIT IS TOTAL AZOLLA ZS 32.

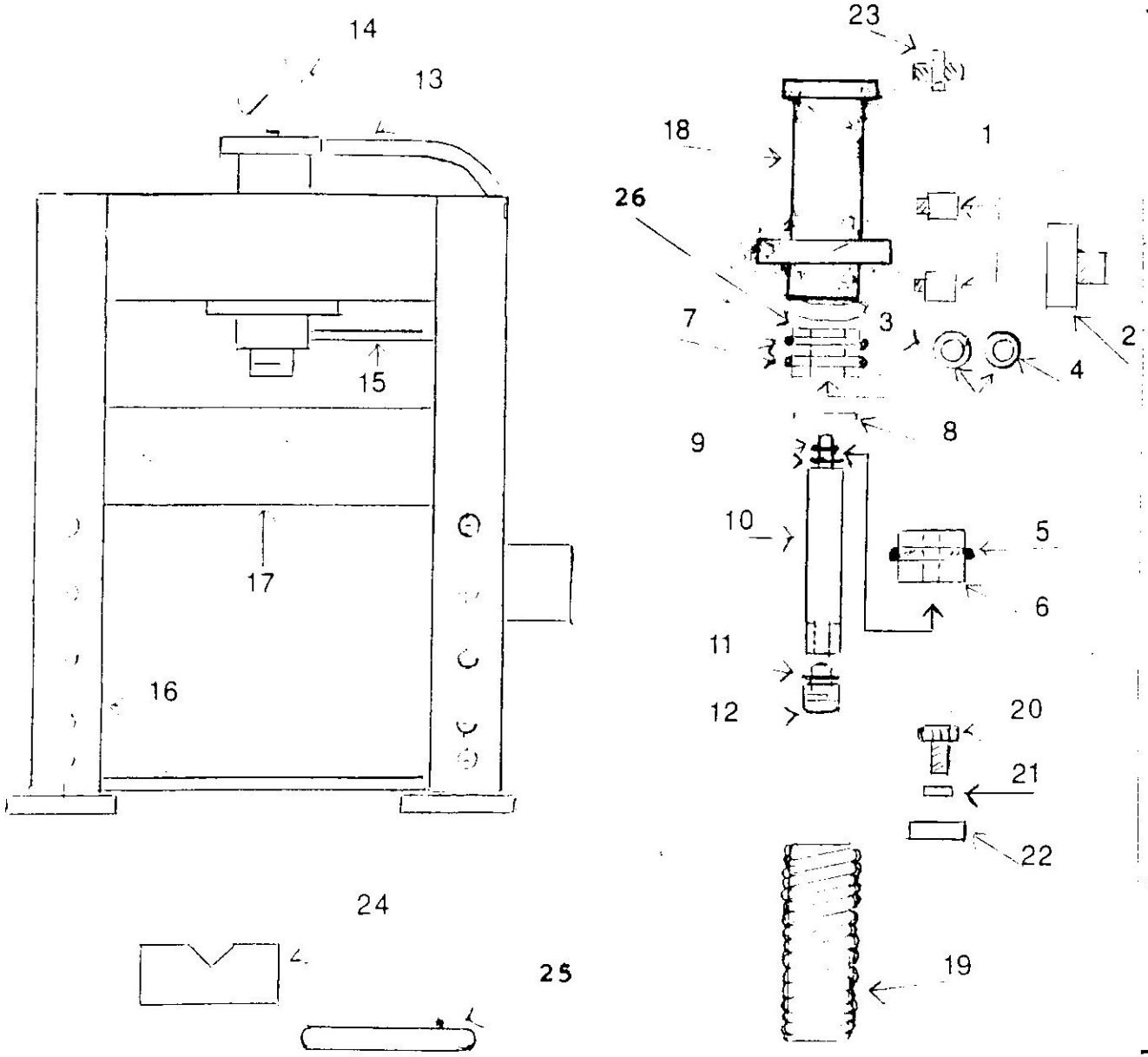
The policy of the Manufacturer is one of continuous improvement and the rights therefore are reserved to modify designs without prior notification.

PCP 20 PUMP PARTS LIST



1	HANDEL
2	RELEASE KNOB
3	"O" RING
4	"O" RING
5	RELEASE BODY
6	RELEASE SPINDLE
7	BALL BEARING
8	DOWTY WASHER
9	MALE/MALE FITTING
10	OLIVE
11	GLAND NUT
12	GLAND NUT
13	OLIVE
14	"T" FITTING
15	OLIVE
16	GLAND NUT
17	OLIVE
18	GLAND NUT
19	PISTON ROD
20	"O" RING
21	"O" RING
22	PISTON BARREL
23	PISTON BARREL END
24	FILTER
25	FILTER
26	RETAINING WASHER
27	DOWTY WASHER
28	MALE/MALE FITTING
29	OLIVE
30	GLAND NUT
31	GLAND NUT
32	OLIVE
33	MALE/MALE FITTING
34	DOWTY WASHER
35	OVERLOAD BODY
36	BALL BEARING
37	PAD
38	SPRING
39	GRUB SCREW
40	DOWTY WASHER
41	MALE/MALE FITTING
42	RETURN PIPE LOCK FITTING
43	HANDLE LINK
44	BOLT
45	BOLT
46	BOLT
47	NUT
48	NUT
49	NUT
50	PIPE
51	"U"PIPE
52	"HOOK" PIPE
53	PUMP PLATE





PART No.	DESCRIPTION.	QTY.
01	STRAIT CONNECTOR	2
02	TEE CONNECTOR	1
03	"O" RING	1
04	SCRAPER SEAL	1
05	SEAL	1
06	PISTON	1
07	"O" RING	2
08	CIRCLIP	1
09	"O" RING	2
10	PISTON ROD	1
11	LOCK RING	1
12	END CAP	1
13	HYDRAULIC HOSE	1
14	GAUGE	1
15	BY PASS TUBE	3
16	MAIN FRAME	1
17	PRESS TABLE	1
18	HYDRAULIC CYLINDER	1
19	CYLINDER SPRING	1
20	PISTON SECURING BOLT	1
21	SPRING WASHER	1
22	PISTON SECURING WASHER	1
23	HYDRAULIC HOSE CONNECTOR	1
24	"V" BLOCK	2
25	TABLE SUPPORT PIN	2
26	PISTON ROD GUIDE	1

WHEN ORDERING SPARE PARTS. QUOTE PRESS MODEL No. AND PARTS LIST No.
I/E PRESS No. CE-15-F PARTS LIST No.10 PISTON.
ORDER CE-15-F-10. PISTON ROD.

DRAWING No. CE-15-14

WARNING

DO NOT ADD HYDRAULIC OIL

FACTORY FILLED

READ INSTRUCTIONS

ON RECEIPT OF YOUR WORKSHOP PRESS READ AND UNDERSTAND THE FITTING INSTRUCTION FOR THE PRESSURE GAUGE AND THE INSTRUCTIONS FOR OPERATING THE WORKSHOP PRESS. FAILURE TO OBSERVE THIS MAY RESULT IN A PRESS MALEFUNCTION.

WERE A PRESSURE GAUGE ADAPTOR IS NOT SUPPLIED THE PRESSURE GAUGE WILL FIT DIRECT INTO THE HYDRAULIC CYLINDER.

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1 REMOVE THREAD PROTECTOR CAP FROM HYDRAULIC CYLINDER.
2 ENSURE P-T-F-E TAPE IS ATTACHED TO GAUGE THREAD.
3 ENSURE GAUGE IS NOT FITTED WITH A CROSS THREAD. DO NOT OVER TIGHTEN GAUGE AS TAPER THREAD IN HYDRAULIC CYLINDER WILL SEAL ON PARALLEL THREAD OF GAUGE.
4 USE THE CORRECT SIZE SPANNER ON GAUGE HEX. NUT.
5 IF OIL STILL SEEPS PASS THE GAUGE THREAD AND P-T-F-E TAPE HAS BEEN ATTACHED TO THE GAUGE THREAD TURN GAUGE ONE MORE TURN

TO FIT A PRESSURE GAUGE COMPLETE WITH ADAPTOR.

USING ASSY. DRAWING FIT ADAPTOR TO GAUGE USE P-T-F-E TAPE TO GAUGE AND ADAPTOR ENSURE SEALING RING IS FITTED BETWEEN GAUGE AND ADAPTOR FIT GAUGE COMPLETE WITH ADAPTOR TO HYDRAULIC CYLINDER TIGHTEN GAUGE TO ADAPTOR DO NOT USE EXCESSIVE FORCE, TIGHTEN ASSY. TO HYDRAULIC CYLINDER, ENSURE GAUGE OR ADAPTOR ARE NOT CROSS THREAD. DO NOT OVER TIGHTEN AS TAPER THREAD IN HYDRAULIC CYLINDER WILL SEAL ON PARALLEL THREAD OF ADAPTOR. USE THE CORRECT SIZE SPANNER, IF OIL SEEPS PASS THE THREAD AND P-T-F-E TAPE HAS BEEN USED TURN ADAPTOR ONE MOOR TURN.

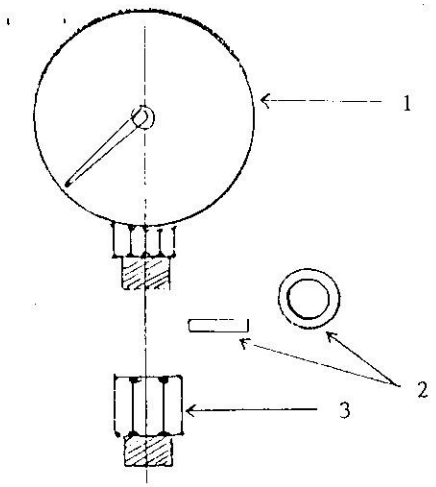
DO NOT OVER TIGHTEN GAUGE OR ADAPTOR OR THREAD COULD BECOME STRIPED ON GAUGE OR ADAPTOR.
CARE MUST BE TAKEN NOT TO CROSS OR STRIP THE THREADS.

1 PRESSURE GAUGE.

2 SEALING RING.

3 GAUGE ADAPTOR.

WERE A PRESSURE GAUGE ADAPTOR IS NOT SUPPLIED. THE PRESSURE GAUGE WILL FIT DIRECT INTO THE HYDRAULIC CYLINDER.



READ AND UNDERSTAND THE INSTRUCTIONS BEFOR USING 262 LOCTITE.

LOCTITE 262 Permanent Strength Thread Locker can be used in place place of P.T.E.F Tape,(A TUBE OF 262 Loctite is Provided with each Press Pressure Gauge.)

DIRECTIONS

1 The Thread in the Hydraulic Cylinder and on the Hydraulic Pressure Gauge must be clean and dry.

2 To open tube snap tube neck below end cap.

3 Apply 262 Loctite to the threaded area on the Pressure Gauge and assemble gauge to the Hydraulic Cylinder, ensure the Gauge. IS NOT FITTED WITH A CROSS THREAD, DO NOT OVER TIGHTEN GAUGE

As the tapper thread in the Hydraulic Cylinder will seal on the Parallel thread of the Pressure Gauge, USE THE CORRECT SIZE SPANNER.

Allow time for Loctite to set.

CAUTION

Loctite contains Methacrylate Ester which may cause Allergic skin rection or eye irritation, In case of eye or skin contact, flush with water and get medical attention for any eye or internal contact.

THE FUNCTION OF THE STROKE RESTRICTOR VALVE FITTED TO ALL WORKSHOP PRESS HYDRAULIC CYLINDERS.

WHEN THE FULL WORKING LENGTH OF THE HYDRAULIC CYLINDER PISTON ROD HAS BEEN REACHED, THE HYDRAULIC OIL WILL PASS FROM THE PRESSURE SIDE OF THE HYDRAULIC CYLINDER TO THE NONE PRESSURE SIDE OF THE HYDRAULIC CYLINDER AND PASS THROUGH THE CLEAR PLASTIC BLEED TUBE TO RETURN TO THE HYDRAULIC PUMP OIL RESERVOIR, AT THIS STAGE THE PRESSURE GUAGE WILL FLUCTUATE INDICATING THAT HYDRAULIC PRESSURE IS BEING LOST. DO NOT CONTINUE TO PUMP ONCE THE FULL PISTON ROD LENGTH HAS BEEN REACHED. AT THIS STAGE HYDRAULIC OIL IS BEING TRANSFERRED FROM THE HYDRAULIC CYLINDER TOP PASS THE PISTON SEAL INTO THE BOTTOM (NONE PRESSURE SIDE) OF THE HYDRAULIC CYLINDER. IF PUMPING IS CONTINUED AT THIS STAGE THE OIL IN THE HYDRAULIC PUMP RESERVOIR WILL TRANSFER TO THE NONE PRESSURE SIDE OF THE HYDRAULIC CYLINDER.

SYMPTONS.

IF THIS CONDITION OCCURS THE PUMP WILL NOT REACH PRESSURE. DO NOT ADD HYDRAULIC OIL. BLEED THE SYSTEM.

1.

OPEN THE HYDRAULIC PUMP RELEASE VALVE AND ALLOW THE HYDRAULIC CYLINDER PISTON ROD TO RETURN TO THE FULLY CLOSED POSITION.

2.

CLOSE HYDRAULIC PUMP RELEASE VALVE.

3.

PUMP UNTILL A MAXIMUM OF 60mm.OF THE HYDRAULIC CYLINDER PISTON ROD HAS BEEN EXTENDED FROM THE HYDRAULIC CYLINDER. AT THIS STAGE DO NOT EXCEED 60mm. OF STROKE. WHEN PUMPING OBSERVE THE CLEAR PLASTIC BY PASS TUBE, OIL WILL PASS THROUGH THE CLEAR PLASTIC BY PASS TUBE AND RETURN TO THE HYDRAULIC PUMP RESERVOIR.
IF HYDRAULIC OIL IS STILL PASSING THROUGH THE CLEAR PLASTIC BY PASS TUBE WHEN 60mm. OF STROKE HAS BEEN REACHED, OPEN THE HYDRAULIC PUMP RELEASE VALVE AND RETURN THE HYDRAULIC CYLINDER PISTON ROD TO THE FULLY CLOSED POSITION, CLOSE THE HYDRAULIC PUMP RELEASE VALVE AND REPEAT ABOVE OPERATION UNTILL AIR BUBBLES APPEAR IN THE CLEAR PLASTIC BY PASS TUBE, IT MAY BE NECESSARY TO REPEAT THIS OPERATION SEVERAL TIMES BEFOR AIR BUBBLES APPEAR IN THE CLEAR PLASTIC TUBE.

4.

OPEN HYDRAULIC PUMP RELEASE VALVE AND RETURN HYDRAULIC CYLINDER PISTON ROD TO THE FULLY CLOSED POSITION. THE HYDRAULIC SYSTEM HAS NOW BEEN BLEED AND THE PRESS IS READY FOR USE. THE FULL HYDRAULIC CYLINDER STROKE CAN NOW BE USED.
THE HYDRAULIC PUMP OIL FILLER CAP MUST REMAINLOOSE AT ALL TIMES WHEN THE PRESS IS BEING USED OR THE SYSTEM IS BEING BLEED.

WARNING

IF THE ABOVE OPERATION IS NOT OBSERVED, OIL IN THE NONE PRESSURE SIDE OF THE HYDRAULIC CYLINDER WILL BE FORCED THROUGH THE SEALS OF THE PISTON ROD.
THIS IS NOT A FAULT AND THE SEALS DO NOT NEED TO BE REPLACED.

IT IS A SAFTY PRECAUTION.

JUST BLEED THE SYSTEM TO REMOVE THE OIL FROM THE NONE PRESSURE SIDE OF THE HYDRAULIC CYLINDER.

WORKSHOP PRESS PRESSURE GAUGE CALCULATIONS

The pressure gauge supplied with each workshop press is calculated in P-S-I and BAR.
Using this method of gauge calculation give a very pricise pressure reading.
A simple method to calculate P-S-I into Tonne is given below.

PRESS CAPACITY.		P-S-I REQUIRED FOR MAXIMUM CAPACITY OF THE PRESS
12 TONNE PRESS	=	3142 P-S-I
15 TONNE PRESS	=	3492 P-S-I
20 TONNE PRESS	=	4582 P-S-I
25 TONNE PRESS	=	3521 P-S-I
30 TONNE PRESS	=	4156 P-S-I
40 TONNE PRESS	=	2873 P-S-I
50 TONNE PRESS	=	3591 P-S-I
60 TONNE PRESS	=	4309 P-S-I
100 TONNE PRESS	=	5727 P-S-I

A 12 Tonne Capacity Press require 3142 P-S-I to achieve 12 Tonne working pressure.

Divide the P-S-I into segments to convert P-S-I to Tonne.

I/E 3142 P-S-I = 12 Tonne pressure ÷ 1571 P-S-I = 6 Tonne pressure 785·5 = 3 Tonne pressure and so on.

IMPORTANT

IF THE OIL CHANGE IS COMPLETED EACH YEAR, OIL TOP UP SHOULD NOT BE REQUIRED.
SHOULD A LEAK OR OIL LOSS OCURR, REMOVE THE PUMP FROM THE HYDRAULIC OIL RESERVOIR.
CHECK THAT THE OIL IS FREE FROM MOISTURE, FOREIGN BODYS, AND HAS NOT BEEN CONTAMINATED IN ANY WAY.
IF TOP UP IS REQUIRED USE ONLY TOTAL AZOLLA ZS 32 HYDRAULIC OIL.
DO NOT MIX BLENDS, DIFFERENT BRANDS OR VISCOSITY HYDRAULIC OILS.

I THE Vee BLOCKS SUPPLIED WITH ALL WORKSHOP PRESSES. CAN BE USED WHEN POSITIONED WITH Vee SLOT REVERSED

2 AS EDGE PARALLEL BLOCKS.

3 AS A PRESSURE PLATE FOR REMOVING BEARINGS FROM A SHAFT WHEN THE PLATES ARE POSITIONED WITH THE Vee IN THE CENTRE FORMING A SQUARE.

4 WITH THE TWO MACHINED Vee.s POSITIONED ON THE OUT SIDE EDGE THE Vee BLOCKS CAN BE USED AS A SOLID PRESSURE PLATE.

INSTRUCTIONS FOR HYDRAULIC WORKSHOP PRESS.

Manufactured to a high standard, this product will, if used in accordance with the instruction and is properly maintained give years of trouble free service.

IMPORTANT

BEFORE USING THIS PRODUCT, PLEASE READ THE INSTRUCTIONS CAREFULLY. MAKE CAREFUL NOTE OF SAFETY INSTRUCTIONS, WARNINGS AND CAUTIONS. THIS PRODUCT SHOULD ONLY BE USED FOR ITS INTENDED PURPOSE. FAILURE TO DO SO MAY CAUSE DAMAGE OR PERSONAL INJURY, AND WILL INVALIDATE THE WARRANTY.

(The use of symbols in this document is to attract your attention to possible danger, and reminders, the symbols and warnings themselves do not eliminate any danger, nor are they substitutes for proper accident prevention measures).

SAFETY INSTRUCTIONS

1. Familiarise yourself with this products application, as well as the limitations and specific potential hazards.
2. Ensure that the workshop press is securely bolted to the floor. The floor must be stable and solid so that the press will not work loose during use.
3. Take special care to avoid trapping hands or feet from falling objects.
4. Use only genuine spare parts, non-recommended parts may be dangerous.
5. Check regularly for damaged parts, broken or damaged parts should be replaced immediately.
6. Ensure the space required for use and maintenance of the press is adequate, and with good lighting.
7. Keep unauthorised persons and children away from the working area at all times.
8. Maintain the press in top condition at all times.
9. Do not use the press for anything other than its intended purpose.
10. Do not exceed the maximum safe working capacity of the press.
11. Do not modify or alter this press in any way.
12. Do not allow children or unauthorised persons to operate this press.
13. Do not use this press unless it is securely bolted to the floor.
14. Do not wear loose or ill-fitting clothing, ties,watches,rings, and any other jewellry, tie up or cover long hair.
15. Do not stand on the press.
16. Do not use the press whilst under the influence of drugs, alcohol or any other intoxicating medication.
17. Do not use the press if you are fatigued.
18. Check that the Press is Level, if shimming is required ensure that the shimming can not work loose.

TO POSITION TABLE

This is accomplished on all models without a winch fitted by lifting the table to the required height, place pins in the relevant location holes in the press frame, making sure that both pins are in line and are located in the front and rear holes of the frame on both sides of the frame, lower the table onto the pins, making sure table is supported on all four location points.

ALWAYS READ THE INSTRUCTIONS BEFORE USING THIS EQUIPMENT

Suitable protection must be enforced if a Press is used to press components that are likely to splinter or shatter or may cause injury.

The Press Ram Piston Rod End Cap must only be used for direct contact with the item being worked. If this is not possible, only use Mandrills/Extensions that are fitted directly to the Press Hydraulic ram Piston Rod. **NEVER** use loose extensions. i.e. socket spanners, tubes, bars etc.

Never push off centre loads or items that are at an angle because of the danger of damage to the Press. And components being dislodged that could cause injury to the operator.

The Press should be fixed firmly to the floor on a level surface and guarding should be used when required. Bench Models should be Fixed Firmly to a suitable Bench/Support. Secure Bench/Support Firmly to Floor.

Use only the handles supplied to operate the equipment. **NEVER** increase the length of handles. **NEVER ALLOW** Winch to freewheel, always hold table on winch handle.

NEVER support or position loads on winch or winch cables. The winch and winch cables are for moving the table only.

TO POSITION TABLE. This is accomplished on all models without winch by lifting table to the required height, place pins in required location holes in frame, making sure that both pins are in line, lower table on to pins. Replace pins at each stage.

On models where a winch is fitted use the winch to lift and lower table to the required height. Replace pins AT EACH STAGE making sure that pins are in line, holding the pressure of the table on winch handle, remove winch locking lever—turn handle to allow table to settle on pins and replace winch locking lever to prevent cable from unspooling from winch.

Winch Ratchet Operates on Lifting Side Only.

NEVER SUPPORT TABLE OR LOAD ON WINCH CABLES. **NEVER** OPERATE PRESS WITH LOAD SUPPORTED ON WINCH CABLES.

ALWAYS replace table support pins and allow table to be supported by pins at all times.

Winch Ratchet operates only when lifting table. Make sure Winch Ratchet is always engaged for this purpose.

When lowering table disengage Ratchet Lever MAKING SURE THE WEIGHT OF THE TABLE IS HELD ON RATCHET HANDLE move table down one set of holes at a time.

REPLACE PINS AT EACH STAGE.

Care should be taken when using the "V" Blocks, position firmly on the supporting table ensure the load is central to the Hydraulic Ram, off centre loads could cause the "V" Blocks to become dislodged from the Press Table.

Any modification to the equipment or the Hydraulic Pump/Ram will make this Declaration of Conformity invalid.

Always use protective wear when using a Hydraulic Press i.e. Safety Glasses.

Be sure all parts of the press/equipment are sound and maintenance is carried out on a regular basis, inspect Hydraulic Flexible Hose etc.

Hydraulic Oil should be changed every 12 month. Never mix different brands of hydraulic oil or use different viscosity.

Care must be taken when using Press/Equipment to protect operator from injury. i.e. trapping fingers/hands/feet etc.

Hydraulic Presses should be released slowly to prevent damage to the hydraulic components. i.e. Pressure Gauge etc. A Stroke Restricter Valve is fitted to all Press Cylinders. To Prevent Accidental Damage to Piston Rod Retaining Guide.

Never continue to exhaust the safety release as this could cause damage to the Safety Release Valve.

NEVER EXCEED THE SAFE WORKING LOADS OF THE EQUIPMENT.

NEVER allow Pressure Gauge Needle to enter the Red Danger Section marked on Pressure Gauge.

NEVER allow Ram to reach full stroke, this could damage Seal or Ram Housing.

NEVER use rods, tubes or any other means to extend the pump handles, if excessive power is employed accidents may occur.